

Process Sheet

Split SB 06/09/28
split ss 06/10/23

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HI-STEP LEG ASSEMBLY	
Job Number	: 27590		Part Number	: D3065041	
Estimate Number	: 10385		Drawing Number	: D3065 REV A2	
P.Q. Number	: N/A		Project Number	: N/A	
This Issue	: 6/15/2006	S.O. No. : N/A	Drawing Revision	: A2	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 6/15/2006	Type : SMALL /MED FAB	Due Date	: 7/2/2006	Qty: 60 Um: Each
Previous Run	: 26928				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	27590A	STEP SPACER
Comment: Sub-Component STEP SPACER		
2.0	27590B	STEP SPACER
Comment: Sub-Component STEP SPACER		
3.0	27590C	STEP LEG
Comment: Sub-Component STEP LEG		
4.0	27590D	STEP SPACER
Comment: Sub-Component STEP SPACER		
5.0	D30651	Step Spacer
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) <i>32</i> Step Spacer Pick: Qty Part Number Description Batch		
1 D3065-1 Spacer <i>B27590A - 32 mx B2452A - 4 mx</i>		
6.0	D30653	Step Spacer
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) Step Spacer Pick: Qty Part Number Description Batch		
1 D3065-3 Spacer <i>B27590B</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/23	10	5# D 3065 -5 D 3065 -7 + 2 D 3065 -1 Roles were out of tolerance	<u>SB</u> <u>06/10/23</u>	Scrap + destroy	<u>SB</u> <u>06/10/23</u>	<u>SB</u> <u>06/10/23</u>	<u>SB</u> <u>06/10/23</u>	<u>SB</u> <u>06/10/23</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	D30655	Step Leg
		Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) 76
		Step Leg
		Pick:
	Qty Part Number	Description
	2 D3065-5	Leg Batch B27590 C
8.0	D30657	Step Spacer
		Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) 33
		Step Spacer
		Pick:
	Qty Part Number	Description
	1 D3065-7	Spacer Batch B27590 D - 33 mx B26928 D - 6m
9.0	MS20470AD44	Rivet, Universal Head
		Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)
		Rivet, Universal Head
		Pick:
	Qty Part Number	Description
	30 MS20470AD4-4	Rivet Batch M100993
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		Assemble as per Dwg D3065 and Identify as D3065-041
11.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
12.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1
		Identify and Stock
		Location: WIA19420

Thursday, 6/15/2006 1:56:03 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06.06.05

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	REV. A SHEET 1 OF 5
		SCALE 1:2
A	02.09.11	NEW ISSUE
A1	03.02.13 (P)	ADD SLOTS TO D3065-5
A2	03.02.27 (P)	0.551 WAS 0.410

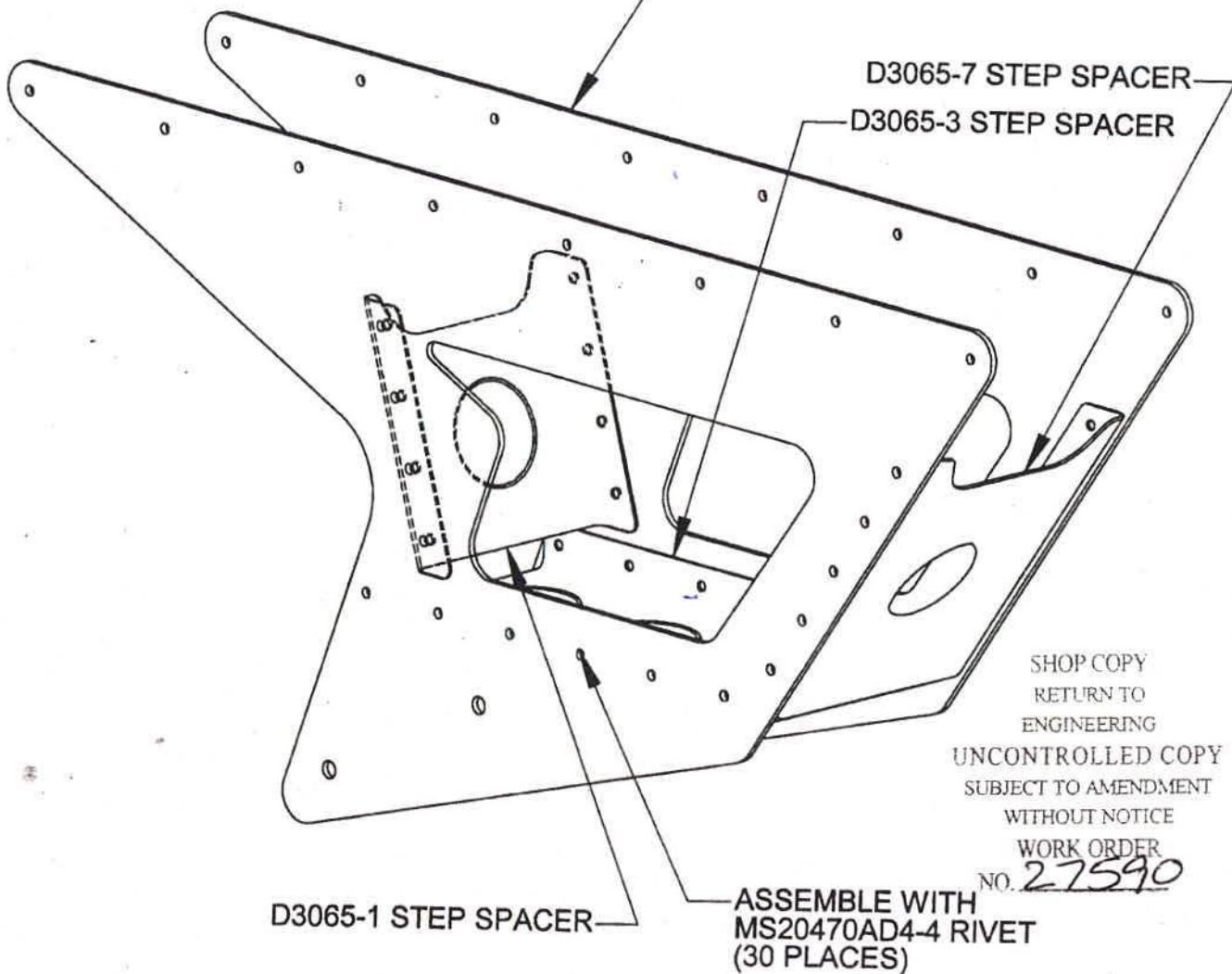
RELEASED
02.09.11

UNDER REVIEW

~~C6.06.02.CB~~
material change

OK

06.06.15



D3065-041 STEP LEG ASSEMBLY

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Dart Aerospace Ltd.

Date: Wednesday, 15/11/2006 3:42:02 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27590	Customer	: Dart Helicopters Services		
Estimate Number	: 10385	DWG Name	: HI-STEP LEG ASSEMBLY		
Purchase Order #	:	Part Number	: D3065041		
Complete Date	: 29/09/2006 11:42:21	DWG Number	: D3065 REV A2	Rev.	: A2
DUEDATE	ORDERED	DELIVERED			
02/07/2006	60	25			
1.0 D30651-Step Spacer SUB-Component/Sub-job					
DATE	EMPLOYEE	TYPE	Qty		
29/09/2006	BOUC01: Boucher, Sylvie		1.000	\$12.01	27590A
Subtotal:					
3.0 D30655-Step Leg SUB-Component/Sub-job					
DATE	EMPLOYEE	TYPE	Qty		
29/09/2006	LACE01: Lacelle, Linda		120.000	\$6211.67	27590C
29/09/2006	LACE01: Lacelle, Linda		5.000	\$258.82	27590C
Subtotal:					
4.0 D30657-Step Spacer SUB-Component/Sub-job					
DATE	EMPLOYEE	TYPE	Qty		
29/09/2006	BOUC01: Boucher, Sylvie		1.000	\$11.06	27590D
Subtotal:					
5.0 D30651-Step Spacer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
29/09/2006	BOUC01: Boucher, Sylvie	D30651	25.000	\$300.22	31 → Lot # 27590A Qty. 25
Subtotal:					
6.0 D30653-Step Spacer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
28/09/2006	BOUC01: Boucher, Sylvie	D30653	25.000	\$380.68	✓ Lot # 21125 Qty. 1 Lot # 22366 Qty. 3 Lot # 22959 Qty. 7 Lot # 23618 Qty. 2 Lot # 26211B Qty. 1 Lot # 26452B Qty. 6 Lot # 26928B Qty. 5
Subtotal:					
8.0 D30657-Step Spacer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
29/09/2006	BOUC01: Boucher, Sylvie	D30657	25.000	\$276.58	✓ 33 → Lot # 27590D Qty. 25
Subtotal:					
9.0 MS20470AD44-Rivet, Universal Head INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
29/09/2006	BOUC01: Boucher, Sylvie	MS20470AD44	1850.000	\$16.47	Lot # 100993 Qty. 1807 Lot # 17944 Qty. 43
Subtotal:					

Date: Wednesday, 15/11/2006 3:42:02 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27590	Customer	: Dart Helicopters Services
Estimate Number	: 10385	DWG Name	: HI-STEP LEG ASSEMBLY
Purchase Order #	:	Part Number	: D3065041
Complete Date	: 29/09/2006 11:42:21	DWG Number	: D3065 REV A2

Rev. : A2

10.0 SMALL FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
28/09/2006	DROU02: Drouin, Steven	Run	0.000	12.15	\$167.06	12.15	486.00
29/09/2006	BOUC01: Boucher, Sylvie	Run	25.000	0.00	\$0.00	0.01	0.40
16/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	2.25	\$25.88	2.25	90.00
17/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	5.25	\$60.38	5.25	210.00
18/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	5.00	\$57.50	5.00	200.00
18/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	2.50	\$28.75	2.50	100.00
19/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	9.75	\$112.13	9.75	390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	9.75	\$112.13	9.75	390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	-9.75	\$-112.13	-9.75	-390.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	1.00	\$11.50	1.00	40.00
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.83	\$9.55	0.83	33.20
20/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.92	\$10.58	0.92	36.80
23/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	4.33	\$49.80	4.33	173.20
23/10/2006	BOUC01: Boucher, Sylvie	Run	0.000	3.17	\$65.65	3.17	126.80
24/10/2006	FAUT01: Fauteux, Melanie	Run	0.000	0.42	\$4.83	0.42	16.80

Subtotal: QTD: 25 CTD: 0 47.57 \$2506.81**11.0 QC5 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
29/09/2006	BOUC01: Boucher, Sylvie	Run	25.000	2.32	\$48.05	2.32	60.32

Subtotal: QTD: 25 CTD: 0 2.32 \$108.37

	Machine Time: Labor: Sub-contract (external Op.): INVENTORY ITEM: SUB-COMPONENT (SUB-JOB):	TIME	COST	
		49.90	\$1963.52	
		49.89	\$651.66	
			\$0.00	
			\$973.95	
			\$6493.56	

Total:

COST PER UNIT: \$403.30

Date: Thursday, 6/15/2006 1:56:33 PM
 User: Kim Johnston

Process Sheet

split
SB 06/09/28

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HI-STEP LEG ASSEMBLY		
Job Number	: 27590 -1			Part Number	: D3065041		
Estimate Number	: 10385			Drawing Number	: D3065 REV A2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 6/15/2006 S.O. No. :			Drawing Revision	: A2		
Prsht Rev.	: NC			Material	:		
First Issue	: 6/15/2006 Type : SMALL /MED FAB			Due Date	: 7/2/2006 Qty: 60 Um: Each		
Previous Run	: 26928						
Written By	:						
Checked & Approved By	: <u>sf</u> 06.06.15						
Comment	: Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	27590A	STEP SPACER	
2.0	27590B	STEP SPACER	
3.0	27590C	STEP LEG	
4.0	27590D	STEP SPACER	
5.0	D30651	Step Spacer	
6.0	D30653	Step Spacer	

Comments and Handwritten Notes:

- Row 1.0: Comment: Sub-Component STEP SPACER D-3065-1
- Row 2.0: Comment: Sub-Component STEP SPACER D-3065-3
- Row 3.0: Comment: Sub-Component STEP LEG D-3065-5
- Row 4.0: Comment: Sub-Component STEP SPACER D-3065-7
- Row 5.0: Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
Step Spacer
- Row 5.0: Pick:
Qty Part Number Description Batch
1 D3065-1 Spacer B2759DA ①
- Row 6.0: Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
Step Spacer
- Row 6.0: Pick:
Qty Part Number Description Batch
1 D3065-3 Spacer B 22959 ④ 23418 ②
B 22346 ③ 23211 ①
B 21125 ① 26452 ⑥
B 22866 ⑤ 26928 ⑦

Date	Step	Description	Initials	Action Corrective	Sign Date	Verifier	Approval	Approver
06/09/29	(o)	<p>10:30a 5-7 10:30 5-1 Roles were our size</p>	DGK SBS	script + replace it	SBS 06/09/29	do. 09/19	GBJ CSD	J 06/09/29

I


Don Williams

Date: Thursday, 6/15/2006 1:56:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Leg

Pick:

Qty	Part Number	Description	Batch
2	D3065-5	Leg	27590C

8.0 D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-7	Spacer	B27590D

9.0 MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
30	MS20470AD4-4	Rivet	H17944 (43) M100993 SAN 06/09/28

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

SAN 06-09-28

80 25

PD

25

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/28

125

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA18#17

BT

FEB 06-09-29

50 25

le: Thursday, 6/15/2006 1:56:03 PM
ver: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27590

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

13.0 DC

Description :

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



P 06/10/02

U 06/9/04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065 REV. A SHEET 1 OF 5
DATE	02.09.11	TITLE STEP LEG ASSEMBLY SCALE 1:2
A	02.09.11	NEW ISSUE
A1	03.07.13 (P)	ADD SLOTS TO D3065-5
A2	03.02.27 (P)	0.551 WAS 0.410

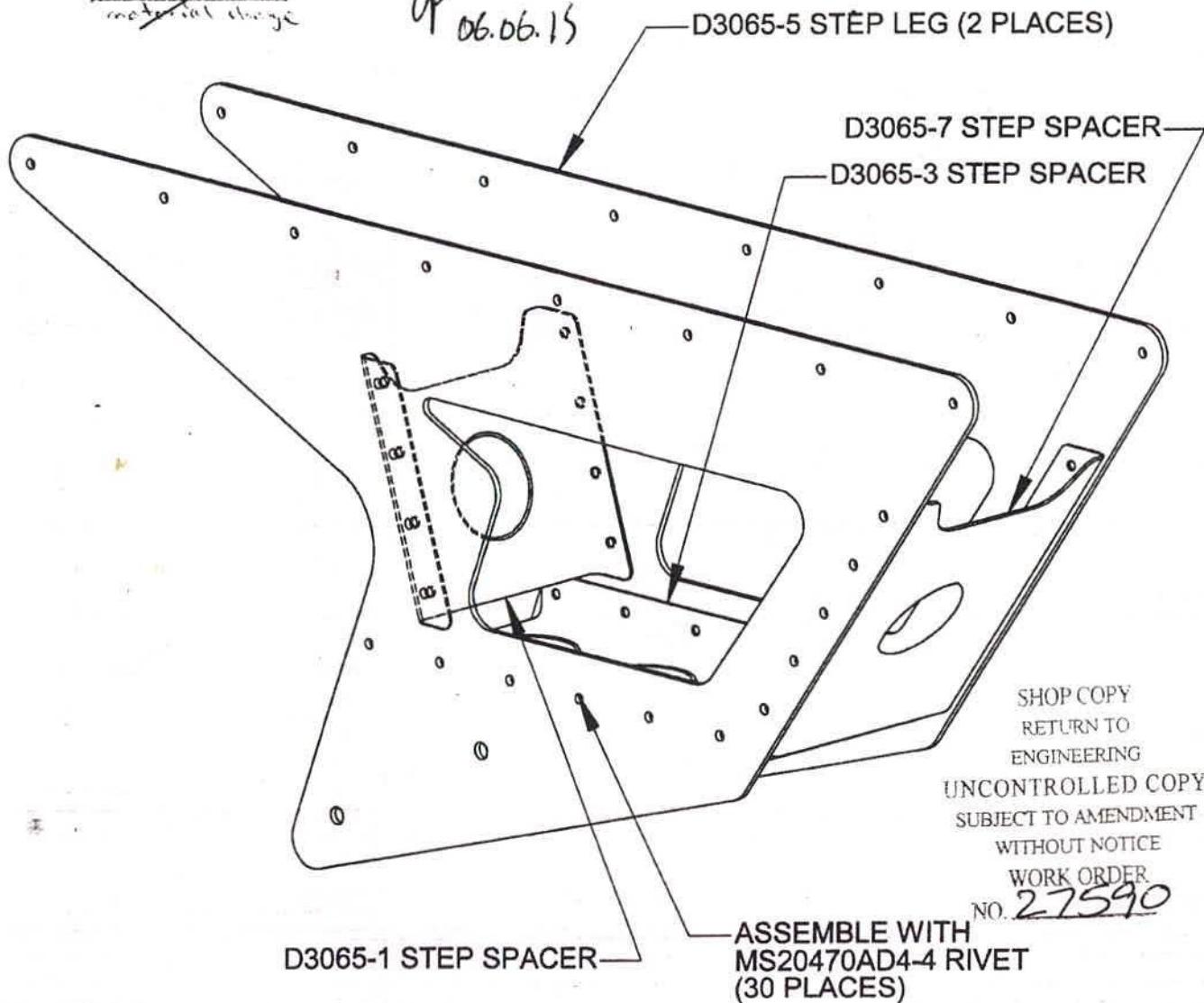
RELEASED
02.01.20 (P)

UNDER REVIEW

06.06.13
material change

OK

(P) 06.06.13



D3065-041 STEP LEG ASSEMBLY

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Date: Thursday, 9/15/2000 1:56:00 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER					
Job Number	: 27590B									
Estimate Number	: 10378									
P.O. Number	:			Part Number	: D30653					
This Issue	: 6/15/2006 S.O. No. :			Drawing Number	: D3065 REV.A2					
Prsh't Rev.	: NC			Project Number	: N/A					
First Issue	: 6/15/2006 Type : SMALL /MED FAB			Drawing Revision	: A2					
Previous Run	: 26928B			Material	:					
Written By	:			Due Date	: 7/2/2006 Qty: 60 Um: Each					
Checked & Approved By	: <u>9A 06.06.15</u>									
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM									
Additional Product										
Job Number:										
Seq. #:	Machine Or Operation:	Description :								
1.0	M2024T3S040	2024-T3 .040 sheet								
Comment:	Qty.: 0.2287 sf(s)/Unit Total: 13.7214 sf(s)	<u>M10/4/17</u>								
Material:	2024-T3 (QQ-A-250/4) 0.040" thick									
(M2024T3S.040)	Batch: <u>M19295</u>	<u>M/ 06.07.10</u>								
2.0	WATER JET	FLOW WATER JET								
Comment:	FLOW WATER JET									
1-Cut as per Dwg D										
Dwg Rev:	<u>A2</u>									
Prog Rev:	<u>A2</u>									
2-Deburr if necessary										
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE								
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<u>M 06.07.10</u> <u>M 06.09.05</u> <u>(60)</u>								
4.0	QC8	SECOND CHECK								
Comment:	SECOND CHECK	<u>Z 06.09.06</u> <u>(60)</u> counted								
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1								
Comment:	SMALL & MEDIUM FAB RESOURCE 1									
Deburr Stack		<u>SAD</u> <u>06.09.10</u> <u>(60)</u>								

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-13	2	61 parts scrap. W.J. Tip was to big, causing the holes Ø.128 to be to large Ø.128 → Ave.138~.142. Operator error.	B 06/07/13 2	Ensure operator verifies set-up before starting. destroy stock & replace.	MM 06-09-05	✓ 06-09-06	B 06-09-12	Z 06-07-13
06-09-16	6	1 part was bend out of T01	B 06/09/16	Scrap + destroy	SB 06/10/16	✓ 06-10-16	B 06-10-12	Z 06-10-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RB Date: 06-11-15

NOTE: Date & initial all entries QA, N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:56:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP SPACER
Job Number: 27590B		Part Number: D30653
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE 8B 06/10/16 59
Comment: NC BRAKE Bend as per Dwg D30653		mf. 06/10/12
7.0	QC5	INSPECT WORK TO CURRENT STEP Job 10-16 (SS) 06/10/16 59
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 am 06/10/16 59
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION m.F. 06/10/17 59
Comment: INSPECT CHEMICAL CONVERSION COAT		
10.0	PACKAGING 1	PACKAGING RESOURCE #1 8B 06/11/15 59
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA		
11.0	DC	DOCUMENT CONTROL 06/11/15 59
Comment: DOCUMENT CONTROL Inspection Level 21		Dokulis
Job Completion		u 06-11-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	02.09.11	D3065	SHEET 1 OF 5 SCALE 1:2

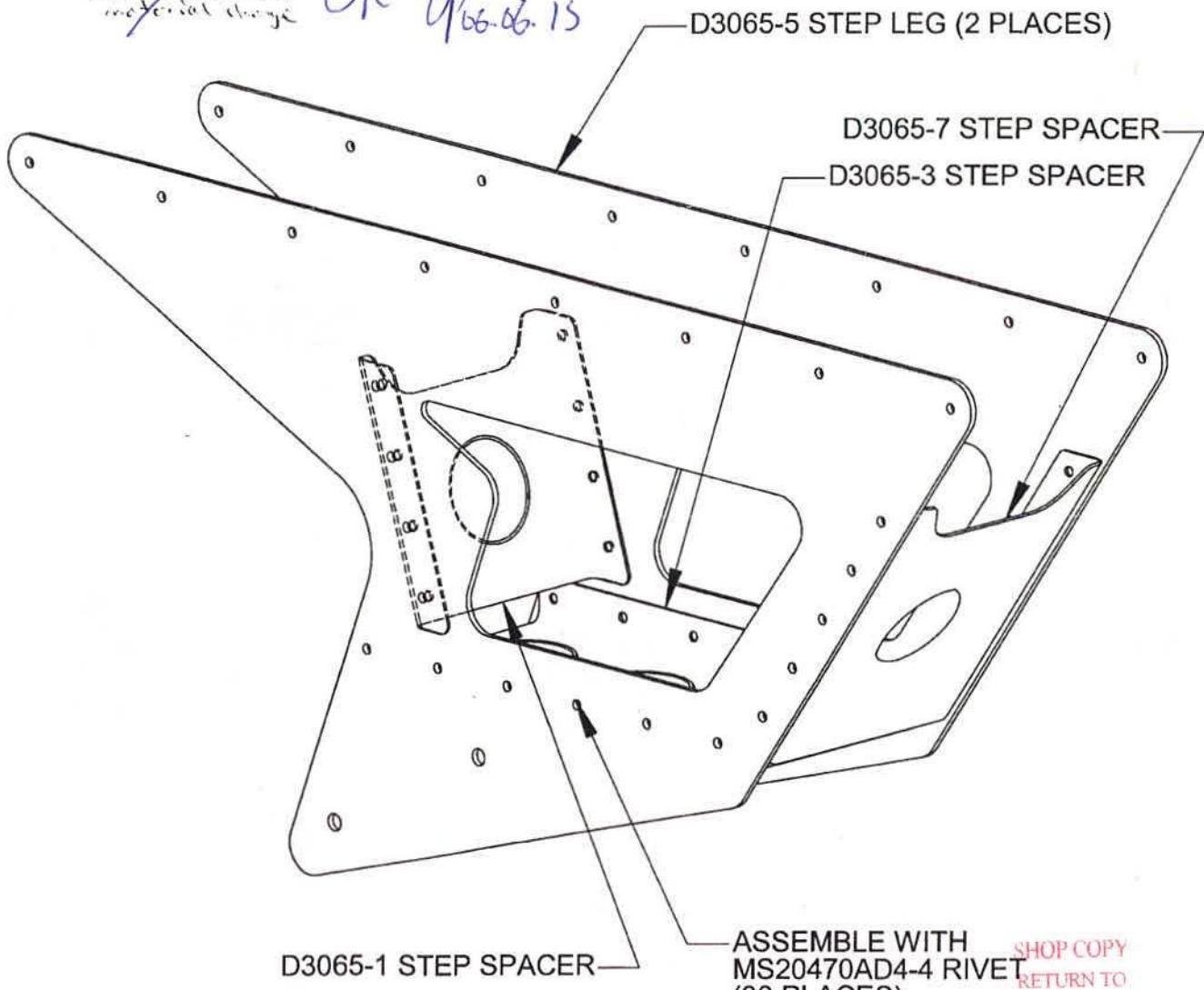
RELEASED
02.01.20 *[Signature]*

A	02.09.11	NEW ISSUE
A1	03.02.13 <i>[Signature]</i>	ADD SLOTS TO D3065-5
A2	03.02.27 <i>[Signature]</i>	0.551 WAS 0.410

~~UNDER REVIEW~~

*[C6.06 02.CB]
material change*

OIL AP 06-06-15



D3065-041 STEP LEG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27590 B*

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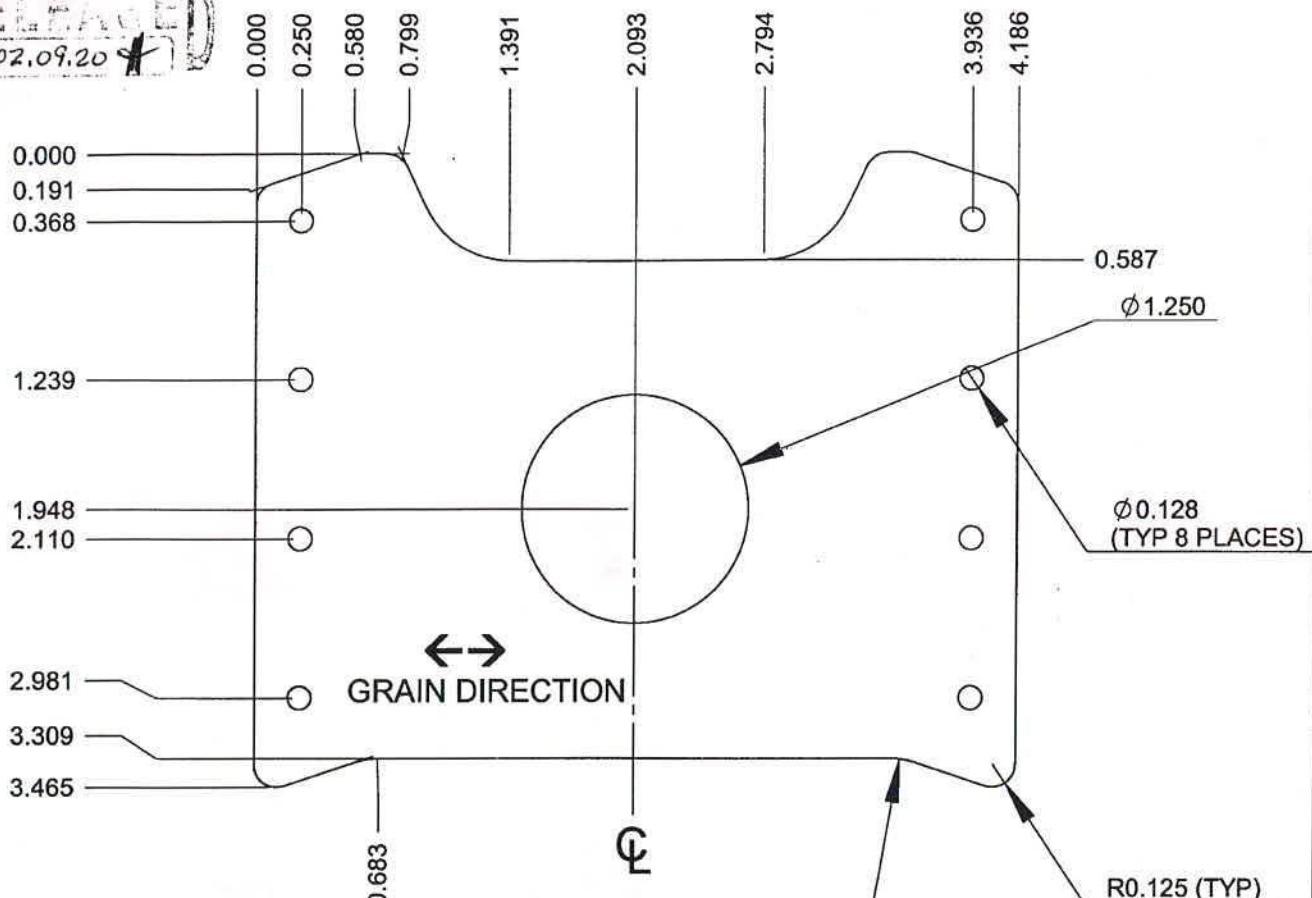
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DART

DESIGN	DRAWN BY
EP	CP
CHECKED	APPROVED
DATE	02.09.11

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

REV. A
SHEET 2 OF 5
SCALE
1:1TITLE
STEP LEG ASSEMBLY**RELEASED**
02.09.20FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)**UNDER REVIEW**C6.000 x C8
material charge

O/L CP 06.06.15

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27590 B

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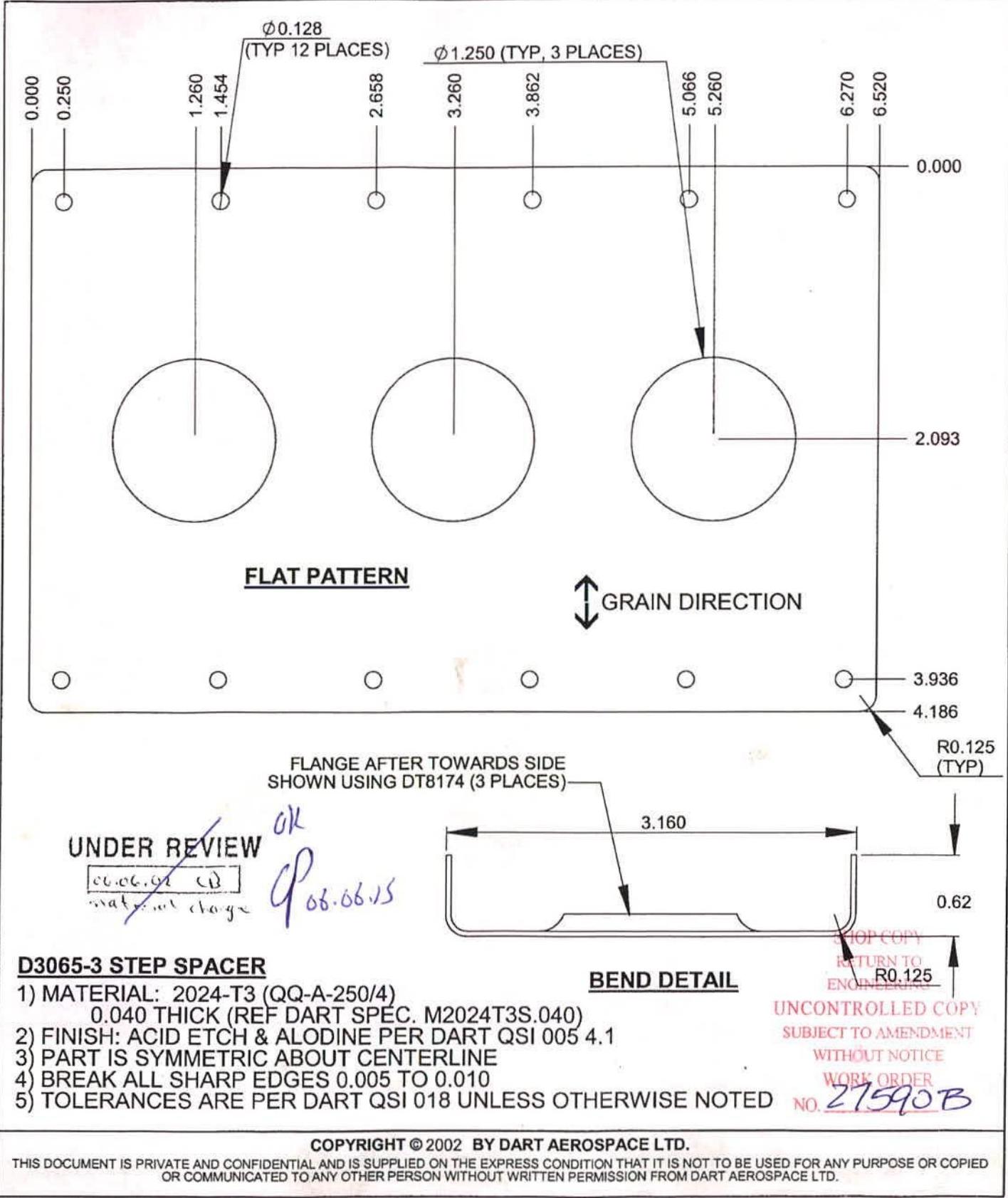
RELEASED
02.09.20

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	TITLE STEP LEG ASSEMBLY

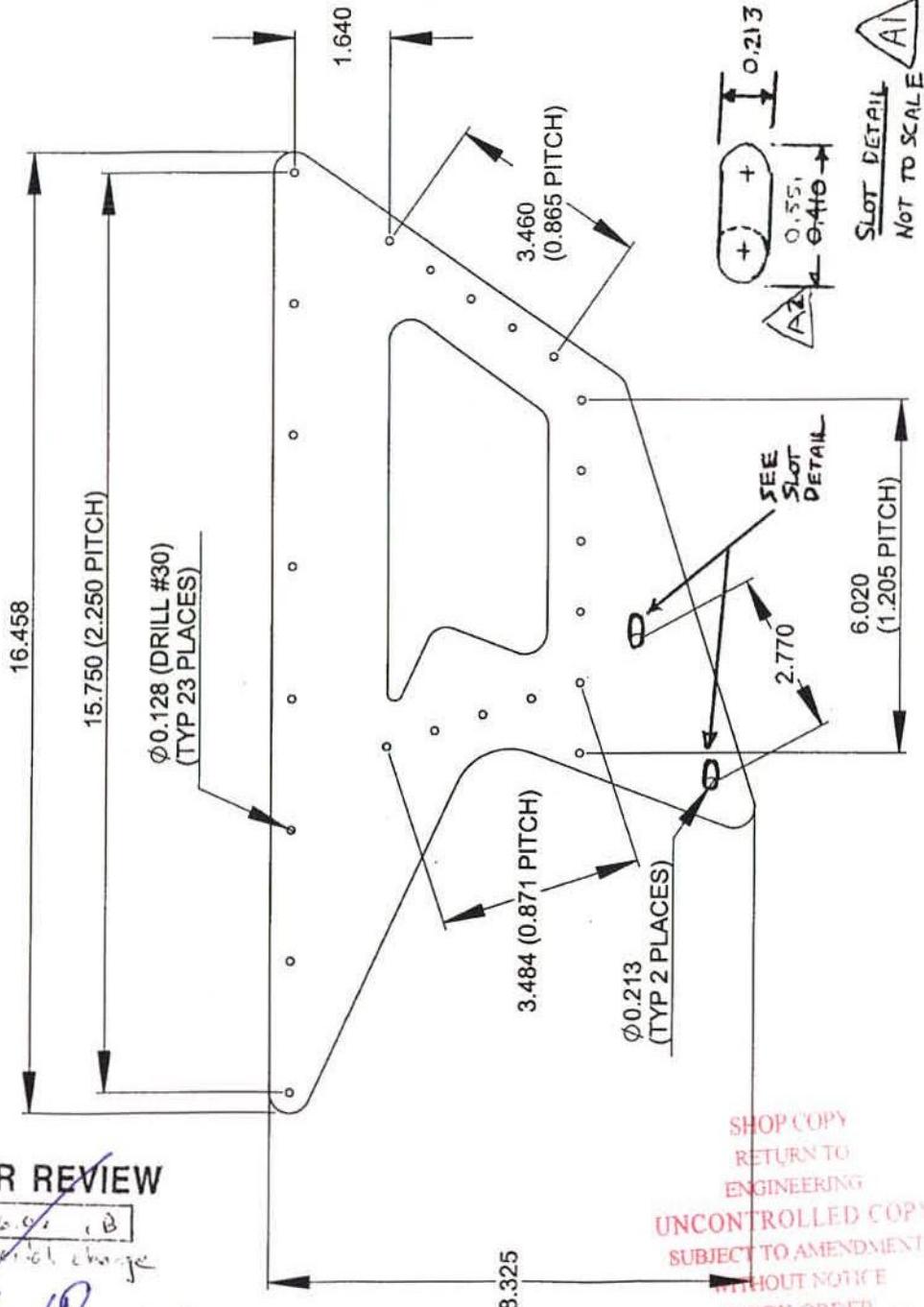
REV. A
SHEET 3 OF 5
SCALE
1:1



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02.09.20 *H*



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D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN

DRAWN BY

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

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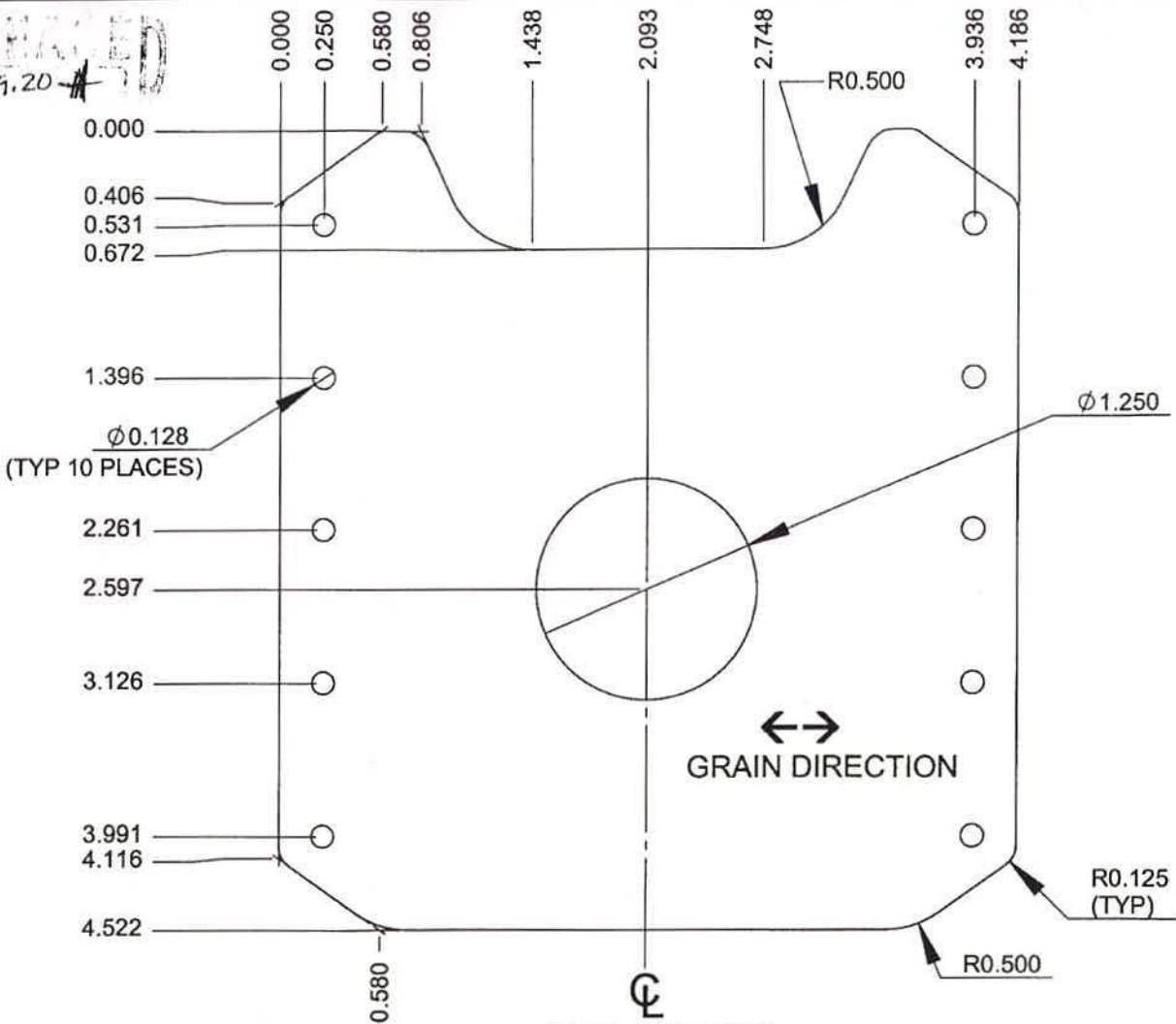
02.09.11

D3065

SHEET 5 OF 5

SCALE

1:1

TITLE
STEP LEG ASSEMBLY~~RELEASER~~
02.09.20~~UNDER REVIEW~~

over due date
material change

OK P.06.06.15

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	27590 B
Description:	Part Number:	3065-3
Inspection Dwg: , Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Audited by:

Prototype Approval:

Measured by:	<i>M. Wolf</i>	Audited by:		Prototype Approval:	
Date:	<i>06.07.10</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>Nel : MM</u>	Audited by:	<u>J</u>	Prototype Approval:	<u> </u>
Date:	<u>06 09 05</u>	Date:	<u>16/05/06</u>	Date:	<u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	